

Work Order ID 72895

Wednesday, August 17, 2011 2:46:11 PM



Page 1

Item ID: D4271-011

Accept



Setup Start



Revision ID:

Item Name: Fwd Beam Assembly

Stop



Start Date: 8/17/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

R

Date:

11/08/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4271

D

100

0.00



Small Fab

Memo

0.00

Small Fab

1 - Pick and Assemble as per dwg

EP 11/08/26 0

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 vlog/rz

(X)

120

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

(P)

1X 11-08-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72895

Wednesday, August 17, 2011 2:46:11 PM



Page 2

Item ID: D4271-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Beam Assembly

Start Date: 8/17/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/29 [Signature]

11/18/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 1

1. The following information is provided for the year ended 31 March 2014:

	£	£
Revenue	100,000	100,000
Cost of sales	(40,000)	(40,000)
Gross profit	60,000	60,000
Operating expenses	(20,000)	(20,000)
Operating profit	40,000	40,000
Finance income	5,000	5,000
Finance costs	(2,000)	(2,000)
Profit before tax	43,000	43,000
Income tax expense	(10,000)	(10,000)
Profit for the year	33,000	33,000

2. The following information is provided for the year ended 31 March 2015:

	£	£
Revenue	110,000	110,000
Cost of sales	(45,000)	(45,000)
Gross profit	65,000	65,000
Operating expenses	(22,000)	(22,000)
Operating profit	43,000	43,000
Finance income	6,000	6,000
Finance costs	(3,000)	(3,000)
Profit before tax	46,000	46,000
Income tax expense	(11,000)	(11,000)
Profit for the year	35,000	35,000

3. The following information is provided for the year ended 31 March 2016:

	£	£
Revenue	120,000	120,000
Cost of sales	(50,000)	(50,000)
Gross profit	70,000	70,000
Operating expenses	(25,000)	(25,000)
Operating profit	45,000	45,000
Finance income	7,000	7,000
Finance costs	(4,000)	(4,000)
Profit before tax	48,000	48,000
Income tax expense	(12,000)	(12,000)
Profit for the year	36,000	36,000

4. The following information is provided for the year ended 31 March 2017:

	£	£
Revenue	130,000	130,000
Cost of sales	(55,000)	(55,000)
Gross profit	75,000	75,000
Operating expenses	(28,000)	(28,000)
Operating profit	47,000	47,000
Finance income	8,000	8,000
Finance costs	(5,000)	(5,000)
Profit before tax	50,000	50,000
Income tax expense	(13,000)	(13,000)
Profit for the year	37,000	37,000

5. The following information is provided for the year ended 31 March 2018:

	£	£
Revenue	140,000	140,000
Cost of sales	(60,000)	(60,000)
Gross profit	80,000	80,000
Operating expenses	(30,000)	(30,000)
Operating profit	50,000	50,000
Finance income	9,000	9,000
Finance costs	(6,000)	(6,000)
Profit before tax	53,000	53,000
Income tax expense	(14,000)	(14,000)
Profit for the year	39,000	39,000

6. The following information is provided for the year ended 31 March 2019:

	£	£
Revenue	150,000	150,000
Cost of sales	(65,000)	(65,000)
Gross profit	85,000	85,000
Operating expenses	(32,000)	(32,000)
Operating profit	53,000	53,000
Finance income	10,000	10,000
Finance costs	(7,000)	(7,000)
Profit before tax	56,000	56,000
Income tax expense	(15,000)	(15,000)
Profit for the year	41,000	41,000

7. The following information is provided for the year ended 31 March 2020:

	£	£
Revenue	160,000	160,000
Cost of sales	(70,000)	(70,000)
Gross profit	90,000	90,000
Operating expenses	(35,000)	(35,000)
Operating profit	55,000	55,000
Finance income	11,000	11,000
Finance costs	(8,000)	(8,000)
Profit before tax	58,000	58,000
Income tax expense	(16,000)	(16,000)
Profit for the year	42,000	42,000

8. The following information is provided for the year ended 31 March 2021:

	£	£
Revenue	170,000	170,000
Cost of sales	(75,000)	(75,000)
Gross profit	95,000	95,000
Operating expenses	(38,000)	(38,000)
Operating profit	57,000	57,000
Finance income	12,000	12,000
Finance costs	(9,000)	(9,000)
Profit before tax	60,000	60,000
Income tax expense	(17,000)	(17,000)
Profit for the year	43,000	43,000

9. The following information is provided for the year ended 31 March 2022:

	£	£
Revenue	180,000	180,000
Cost of sales	(80,000)	(80,000)
Gross profit	100,000	100,000
Operating expenses	(40,000)	(40,000)
Operating profit	60,000	60,000
Finance income	13,000	13,000
Finance costs	(10,000)	(10,000)
Profit before tax	63,000	63,000
Income tax expense	(18,000)	(18,000)
Profit for the year	45,000	45,000

10. The following information is provided for the year ended 31 March 2023:

	£	£
Revenue	190,000	190,000
Cost of sales	(85,000)	(85,000)
Gross profit	105,000	105,000
Operating expenses	(42,000)	(42,000)
Operating profit	63,000	63,000
Finance income	14,000	14,000
Finance costs	(11,000)	(11,000)
Profit before tax	66,000	66,000
Income tax expense	(19,000)	(19,000)
Profit for the year	47,000	47,000

11. The following information is provided for the year ended 31 March 2024:

	£	£
Revenue	200,000	200,000
Cost of sales	(90,000)	(90,000)
Gross profit	110,000	110,000

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the team.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete each task.







4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress regularly to ensure that the project is on track.

5. The final step is to evaluate the results of the project. This involves assessing the outcomes against the objectives and goals and identifying any areas for improvement.

Required Date: 8/25/2011

Required Qty: 1.00

IPP RevC IPP RevA
11.07.20

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4271-025 		Manufactured	No			100	Each	0.0000	1	1			
End Fitting Assembly Fwd Beam						B 72896	(12)					8/11/08/26	
D4275-1 		Manufactured	No			100	Each	3.0000	1	1			
Fwd Beam												8/11/08/26	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				st200			1						
				65884			1						
				WA			2						
				71929			2						
AN3C12A 		Purchased	No			100	Each	90.0000	6	6			
Bolts												8/11/08/26	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST351			90						
				117514			4						
				118112			5						
				118422			49						
				118451			32						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 72895

Parent Item: D4271-011

Parent Item Name: Fwd Beam Assembly

Start Date: 8/17/2011

Required Date: 8/25/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-3

Purchased

No

100

Each

998.0000

6

6



Nut



JS/08/26

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

926

112314

6

118077

420

118614

500

6

NAS1149C0332R

Purchased

No

100

Each

6,288.000

12

12



Washer



JS/08/26

Location

Loc Qty

Loc Code

FP-B

7

117291

7

ST297

6281

116304

55

117460

62

117887

183

118078

2

118179

86

118306

893

118354

5000

12

Wednesday, August 17, 2011 2:46:19 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

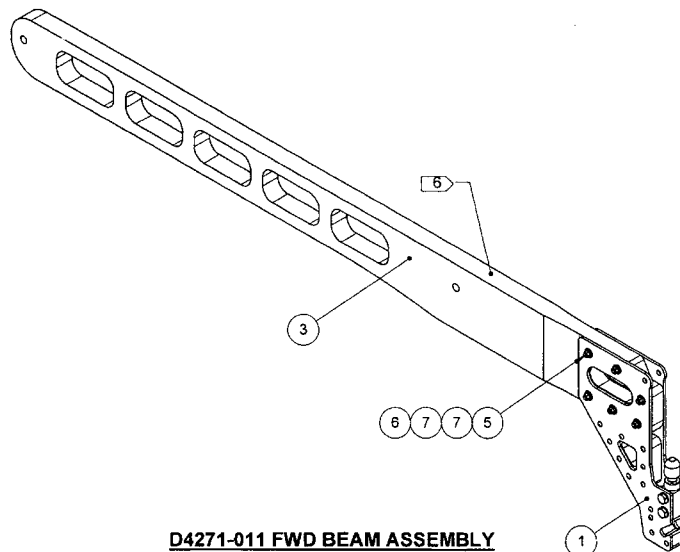
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

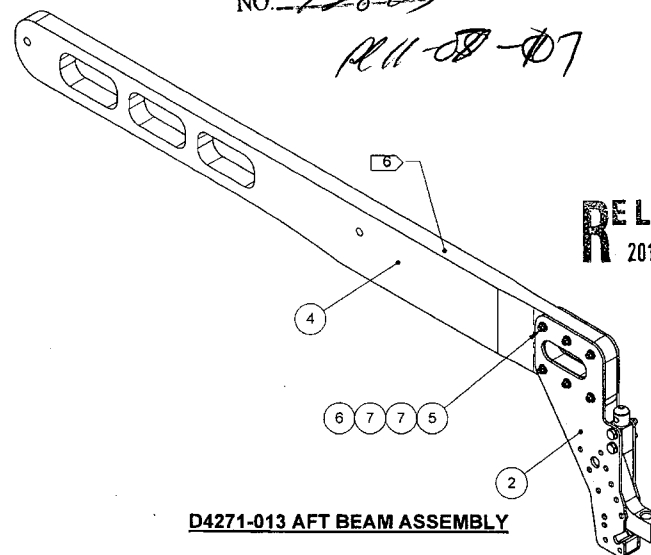
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -011	QTY -013	P/N	DESCRIPTION
	X		D4271-011	FWD BEAM ASSEMBLY
		X	D4271-013	AFT BEAM ASSEMBLY
	-	-	D4271-021	DELETED AT REVISION D
	-	-	D4271-023	DELETED AT REVISION D
1	1	-	D4271-025	FWD BEAM END FITTING ASSEMBLY
2	-	1	D4271-027	AFT BEAM END FITTING ASSEMBLY
3	1	-	D4275-1	FWD BEAM
4	-	1	D4276-1	AFT BEAM
5	6	6	AN3C12A	BOLT
6	6	6	MS21043-3	NUT
7	12	12	NAS1149C0332R	WASHER



D4271-011 FWD BEAM ASSEMBLY



D4271-013 AFT BEAM ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENTS
WITHOUT NOTICE
WORK ORDER
NO. 72825

REV 11-08-07

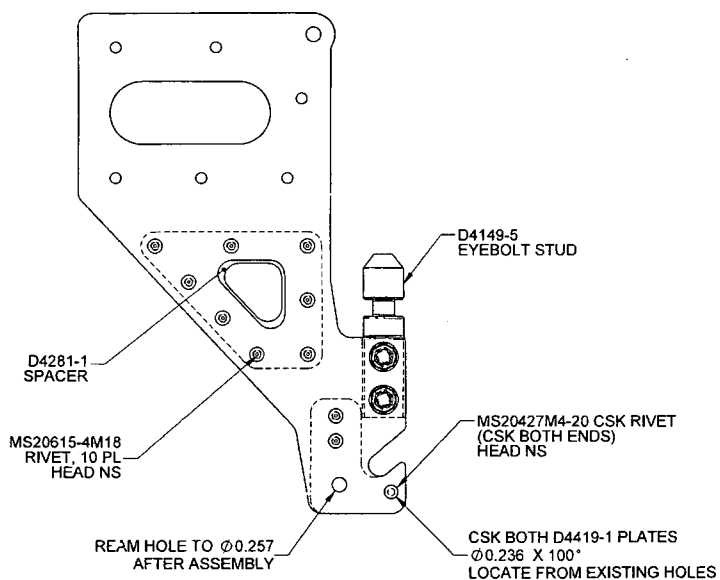
RELEASED
2011-07-28

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4271-0XX" AND B/N "BXXXXX"
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT -011: 11.02 lbs
-013: 12.97 lbs

REV.	DESCRIPTION	BY	DATE
D	DELETED -021 & -023 REPLACED BY -025 & -027 FOR Q.R. STEP INSTALLATION.	AJS	11.07.14
C	ADDED -021 & -023 FOR EASE OF CONFIGURATION MANAGEMENT. REFORMAT SEE PREV REV FOR DETAILS.	AJS	11.07.12
B	ITEM 10 CHANGED FROM AN3C12A TO AN4C13A	SC	10.12.01
A	NEW ISSUE	SC	10.11.25
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4271	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SUPPORT BEAM ASSEMBLIES	NTS
DATE	11.07.14	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

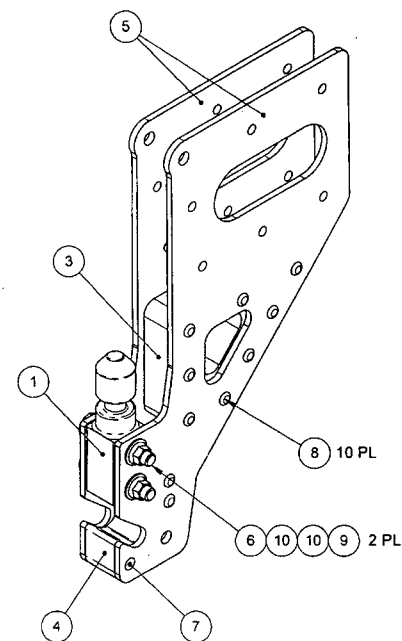
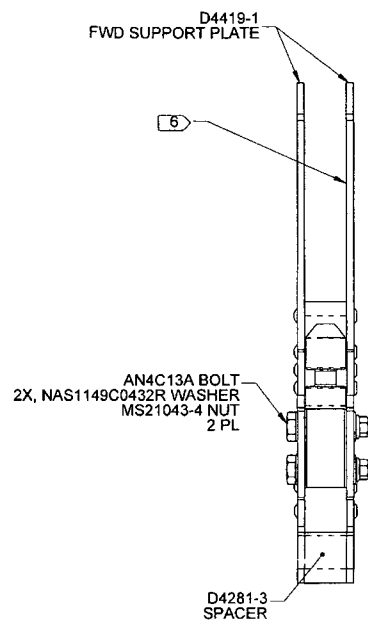
ITEM	QTY -025	P/N	DESCRIPTION
	X	D4271-025	FWD BEAM END FITTING ASSEMBLY
1	1	D4149-5	EYEBOLT STUD
3	1	D4281-1	SPACER
4	1	D4281-3	SPACER
5	2	D4419-1	FWD SUPPORT PLATE
6	2	AN4C13A	BOLT
7	1	MS20427M4-20	CSK RIVET (MONEL)
8	10	MS20615-4M18	RIVET (MONEL)
9	2	MS21043-4	NUT
10	4	NAS1149C0432R	WASHER



D4271-025 FWD BEAM END FITTING ASSEMBLY




NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4271-025" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 2.69 lbs

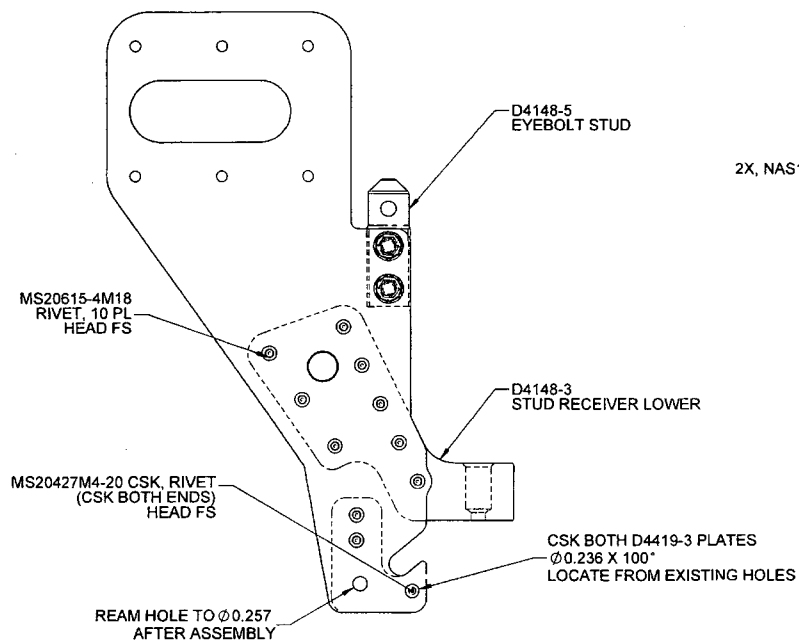


RELEASED
2011-07-28

72895

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4271	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT BEAM ASSEMBLIES	NTS
DATE	11.07.14	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

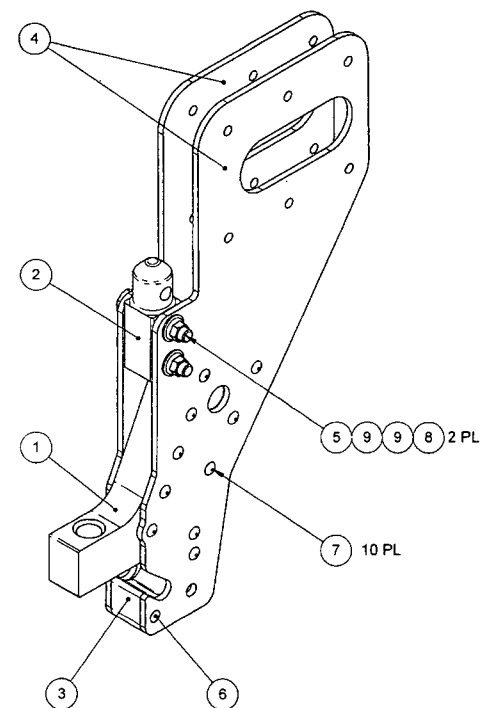
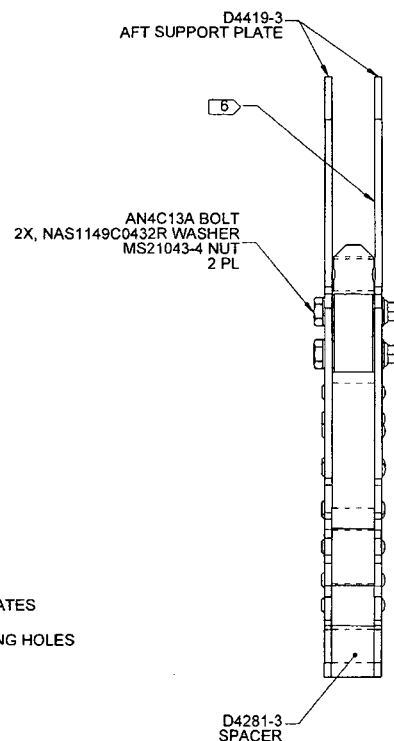
ITEM	QTY -027	P/N	DESCRIPTION
	X	D4271-027	AFT BEAM END FITTING ASSEMBLY
1	1	D4148-3	STUD RECEIVER LOWER
2	1	D4148-5	EYEBOLT STUD
3	1	D4281-3	SPACER
4	2	D4419-3	AFT SUPPORT PLATE
5	2	AN4C13A	BOLT
6	1	MS20427M4-20	CSK RIVET (MONEL)
7	10	MS20615-4M18	RIVET (MONEL)
8	2	MS21043-4	NUT
9	4	NAS1149C0432R	WASHER



D4271-027 AFT BEAM END FITTING ASSEMBLY





NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4271-027" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 4.25 lbs



72825

RELEASED
2011-07-28

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4271	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT BEAM ASSEMBLIES NTS	
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